

PPG AQUACOVER™ ONE 645

DESCRIPTION

One-component, waterborne acrylic dispersion finish

PRINCIPAL CHARACTERISTICS

- Finish for interior accommodations, machinery spaces and engine rooms
- Particularly suitable when solvents are not permitted because of health and safety reasons
- Fast-drying and recoatable
- Good weather resistance
- Good color retention
- Allows safer working during hull outfitting of new-buildings

COLOR AND GLOSS LEVEL

- White (other colors available on request)
- Gloss

BASIC DATA AT 20°C (68°F)

Data for product	
Number of components	One
Mass density	1.2 kg/l (10.0 lb/US gal)
Volume solids	44 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 4.0 g/kg
Recommended dry film thickness	50 - 100 µm (2.0 - 4.0 mils) per coat
Theoretical spreading rate	8.0 m²/l for 50 µm (321 ft²/US gal for 2.0 mils)
Dry to touch	1 hour
Overcoating Interval	Minimum: 12 hours Maximum: Unlimited
Shelf life	At least 24 months when stored cool and dry

Notes:

- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Curing time

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Substrate conditions

- Compatible previous coat must be dry and free from any contamination



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Substrate temperature and application conditions

- Substrate temperature during application should be at least 10°C (50°F)
 - Substrate temperature during application should be at least 3°C (5°F) above dew point
 - Relative humidity during application should not exceed 75%
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INSTRUCTIONS FOR USE

- Stir well before use
 - The temperature of the paint should preferably be above 15°C (59°F), otherwise extra thinner may be required to obtain application viscosity
 - Too much tap water results in reduced sag resistance
 - Adequate ventilation must be maintained during application and curing
 - Must be protected from freezing at all times during storage and/or transport
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Air spray**Recommended thinner**

Tap water

Volume of thinner

5 - 10%, depending on required thickness and application conditions

Nozzle orifice

1.8 - 2.0 mm (approx. 0.070 - 0.079 in)

Nozzle pressure

0.3 - 0.4 MPa (approx. 3 - 4 bar; 44 - 58 p.s.i.)

Airless spray**Recommended thinner**

Tap water

Volume of thinner

0 - 5%, depending on required thickness and application conditions

Nozzle orifice

Approx. 0.46 - 0.53 mm (0.018 - 0.021 in)

Nozzle pressure

12.0 - 15.0 MPa (approx. 120 - 150 bar; 1741 - 2176 p.s.i.)



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Brush/roller

- Long haired brush or polyether roller with rounded edges

Recommended thinner

Tap water

Volume of thinner

0 – 5%

Cleaning solvent

Tap water and THINNER 40-25

Note: Please contact your PPG representative for availability in your region

Cleaning procedures

- Pulsator filter and tip filter must be taken out of the equipment and cleaned properly
- The following tables illustrate the cleaning procedure of the spray equipment when changing from spraying with solvent-borne paint to waterborne paints (table 1) and from waterborne paints to solvent-borne paints (table 2)

Table 1: Cleaning procedure from solvent-borne to waterborne paints

Steps	Cleaning text
1st cleaning	THINNER 90-53
2nd cleaning	THINNER 40-25
3rd cleaning	With warm tap water of 30°C (86°F) to 35°C (95°F) after which waterborne paints can be sprayed

Table 2: Cleaning procedure from waterborne to solvent-borne paints

Steps	Cleaning text
1st cleaning	Warm tap water of 30°C (86°F) to 35°C (95°F)
2nd cleaning	THINNER 40-25
3rd cleaning	THINNER 90-53

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ADDITIONAL DATA

Overcoating interval for DFT up to 75 µm (3.0 mils)				
Overcoating with...	Interval	10°C (50°F)	20°C (68°F)	30°C (86°F)
itself	Minimum	16 hours	12 hours	8 hours
	Maximum	Unlimited	Unlimited	Unlimited

Note: Surface must be dry and free from any contamination

SAFETY PRECAUTIONS

- See Safety Data Sheet and product label for complete safety and precaution requirements
- Although this is a waterborne paint, care should be taken to avoid inhalation of spray mist, as well as contact between the wet paint and exposed skin or eyes

WORLDWIDE AVAILABILITY

It is always the aim of PPG Protective and Marine Coatings to supply the same product on a worldwide basis. However, slight modification of the product is sometimes necessary to comply with local or national rules/circumstances. Under these circumstances an alternative product data sheet is used.

REFERENCES

- EXPLANATION TO PRODUCT DATA SHEETS
- INFORMATION SHEET
- 1411

WARRANTY

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